

PN - DE19613134 A1 19971002  
 PD - 1997-10-02  
 PR - DE19961013134 19960401  
 OPD - 1996-04-01  
 TI - (A1)  
     Hollow plastic product manufacture and process plant  
 AB - (A1)  
     In a process for moulding a plastic product(6) with one or more hollow chambers a polymer melt is injected into a tool cavity(2) and simultaneously or subsequently a first pressurised fluid, preferably compressed gas, is injected into the melt via a nozzle(7) to form a hollow cavity and press the melt against the cavity walls. A second pressurised fluid, preferably a compressed gas, is also injected into the cavity(2) at a pressure(PGG) greater than atmospheric and acts against the melt flow to control growth of the internal gas bubble. Process equipment comprises a tool(1) with one or more cavities(2), an injection unit(4,5) with a melt injection nozzle(3), an injection nozzle(7) for injecting the first pressurised fluid and an arrangement(8) for injecting the second pressurised fluid into the cavity(2).  
 IN - (A1 C2)  
     ECKARDT HELMUT [DE]; EHRITT JUERGEN [DE]  
 PA - (A1 C2)  
     BATTENFELD GMBH [DE]  
 EC - B29C45/17B; B29C45/17B2  
 IC - (A1)  
     B29C45/03  
     - (C2)  
     B29C45/00  
 CT - (A1 C2)  
     DE3913109 C2 [ ]; DE2800482 A1 [ ];  
     US4101617 A [ ]

TI - Hollow plastic product manufacture and process plant - which injects melt into tool cavity, followed by pressurised fluid to create hollow chamber and simultaneously feeding second pressurised fluid cavity to control the melt flow  
 PR - DE19961013134 19960401  
 PN - DE19613134 C2 20000727 DW200037 B29C45/00 000pp  
     - DE19613134 A1 19971002 DW199745 B29C45/03 013pp  
 PA - (BATW ) BATTENFELD GMBH  
 IC - B29C45/00 ;B29C45/03  
 IN - ECKARDT H; EHRITT J  
 AB - DE19613134 In a process for moulding a plastic product(6) with one or more hollow chambers a polymer melt is injected into a tool cavity(2) and simultaneously or subsequently a first pressurised fluid, preferably compressed gas, is injected into the melt via a nozzle(7) to form a hollow cavity and press the melt against the cavity walls. A second pressurised fluid, preferably a compressed gas, is also injected into the cavity(2) at a pressure(PGG) greater than atmospheric and acts against the melt flow to control growth of the internal gas bubble. Process equipment comprises a tool(1) with one or more cavities(2), an injection unit(4,5) with a melt injection nozzle(3), an injection nozzle(7) for injecting the first pressurised fluid and an arrangement(8) for injecting the second pressurised fluid into the cavity(2).

- ADVANTAGE - Better surface quality is achieved by a more controlled melt flow which prevents the gas bubble breaking through the melt.

- (Dwg.1/9)

OPD - 1996-04-01

AN - 1997-481907 [45]

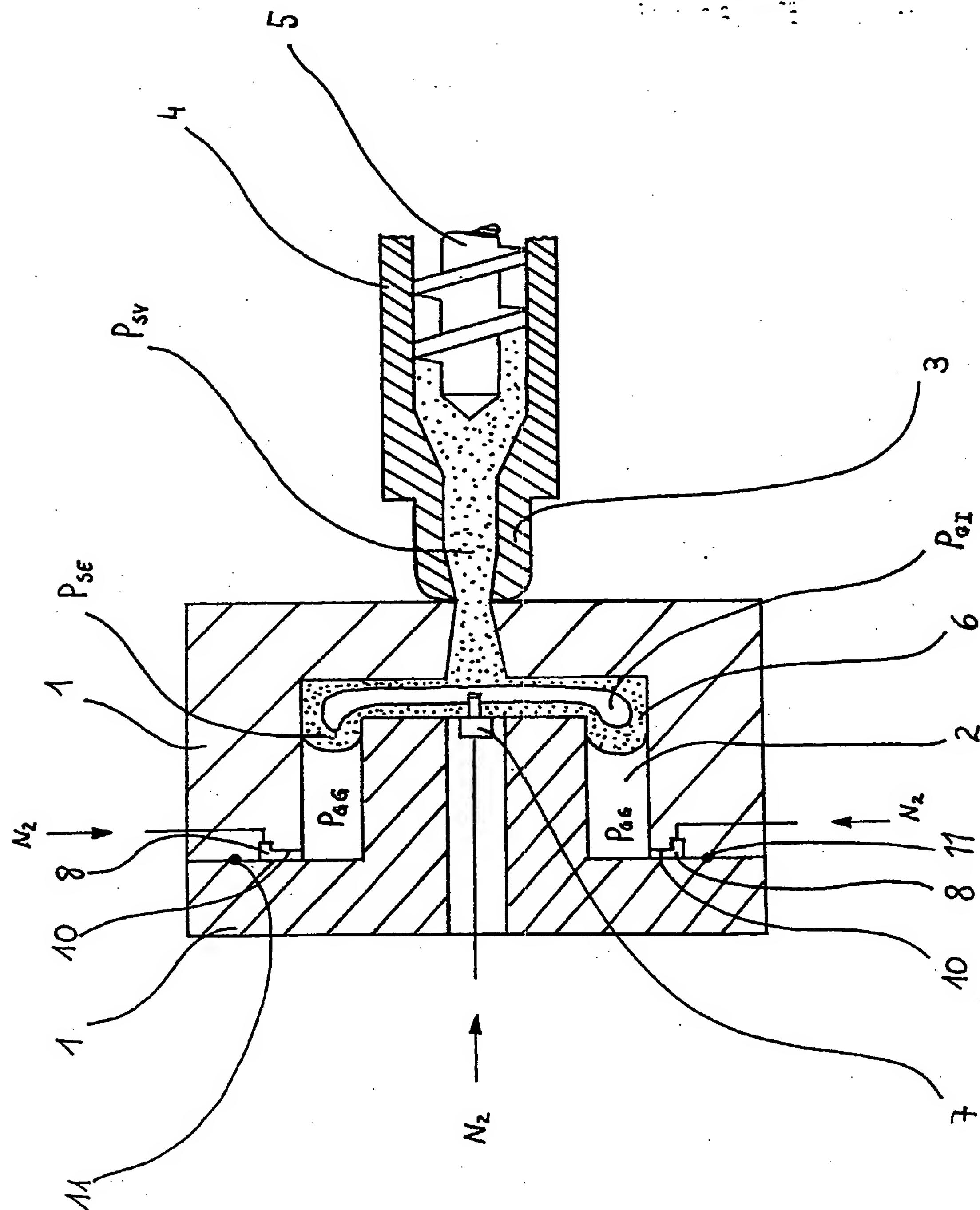


Fig. 1